

5/20

DART AEROSPACE LTD	Work Order:	23195
Description: Placard	Part Number:	D3214-1
#05.05.06		
Dwg: D3214 Rev. A I	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	A	05/05/09	10
2	GA	Cut blanks: 3.70" x 2.70" Material: 5052-H32/H34 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Identify for D3214-1			
		Batch: M 17695	SP	05/06/07	10
3	GA	Drill hole and fillet corner as per Dwg D3214	SP	05/06/07	10
4	GA	Deburr Identify as D3214-1	SP	05/06/07	10
5	QC5	Inspect work to Step 4	2	05-07-05	10
6	FP	Chemical Conversion Coat as per QSI 005 4.1	MD	05-07-05	10
7	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	MD	05-07-06	10
8	QC3	Inspect Powder Coat	2	05-07-11	10
9	MV	Engrave text as per Folio FA394 and Dwg D3214	SD	05.07.13	10
10	QC2	Inspect parts as they come off the CNC machine	SD	05.07.13	10
11	QC8	Second check	RE	05-07-13	10
12	ST	Identify and Stock	CH	05/07/14	10
13	AC	Cost / part 7.58	AP	05/07/15	10
14	DC	Close W/O 8.29 Inspect Level 21	AP	05.07.15	10

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	

RELEASED

04-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3214	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE PLACARD	SCALE 1:1
A	04.01.27	NEW ISSUE	
A1	<i>RF</i> 04.05.14	CORRECT TYPO: 4.3 WAS 4.1	

RELEASED
04.04.05 *RF*

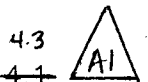


D3214-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23195

NOTES

- 1) MATERIAL: 5052-H32 /H34 (QQ-A-250/8) 0.080 THICK (M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.1
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



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Job Costing Report

Dart Aerospace Ltd..
Hawkesbury

May 06, 2005
09:55 am

Work Order No : 0023195
Project Name : D3214-1
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3214-1
Description : Placard
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-05-05
Est Finish Date : 05-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00